

# Work Order ID 67168



Page 1

Wednesday, March 09, 2011 12:52:47 PM

Item ID: D135-692-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 3/9/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 3/16/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

*PL*

Date: 11-03-9

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3049

Rev A1

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D135-692-011 CHG002

*8 wbs/23*

*HJ for BG 11-3-22*

150

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

*11/3/22 30 SF*

160

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

*8 wbs/23*

*(+3)*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 67168**

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Page 2

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Date:

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		0.00							
	Packaging								
Packaging	<b>Memo</b>	0.00							
Packaging	Identify and pack for shipping as per PPP D135-692-011								
	Location: <u>SIA</u>								
	PPP Rev: <u>SIA</u>								
180		0.00							
	QC21- Final Inspection - Work Order Release								
QC	<b>Memo</b>	0.00							
Quality Control									

*CL 3/23* (3) (3x)

*11/3/23*

*CL 11/03/23*

**Dart Aerospace Ltd**

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, March 09, 2011 12:52:54 PM

Page 1

Work Order ID: 67168

Parent Item: D135-692-011

Parent Item Name: Bearpaw



Start Date: 3/9/2011

Required Date: 3/16/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev: C 04.02.17 Blank size changed, Tolerance added Step 3 KJ/JLM  
IPP Rev: D 08-04-16 Added Step 2 JLM Verified By: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------



Bolt

Purchased

No

160

Each

330.0000

8

24

## Location

## Loc Qty

## Loc Code

ST308

316

116786

316

ST358

14

114784

9

115108

5

AN960JD416

NAS1149D0463J

Purchased

No

160

Each

30.0000

8

24

Washer

## Location

## Loc Qty

## Loc Code

ST300

24

113288

24

ST356

6

115622

6

D2182B

Manufactured

No

160

f

461.3681

2

6

Rubber Cushion

## Location

## Loc Qty

## Loc Code

ST410

461.36811

63413

111.36811

66063

350

(D2182B060) Gut.4 at 6.00"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, March 09, 2011 12:52:54 PM

Page 2

Work Order ID: 67168

Parent Item: D135-692-011

Parent Item Name: Bearpaw

Start Date: 3/9/2011

Required Date: 3/16/2011

Start Qty: 3.00

Required Qty: 3.00

D2274



Radius Block

Manufactured No

160

Each

484.0000

8

24

11/3/22

Location

Loc Qty

Loc Code

ST010

484

61361

1

63990

6

65562

104

65757

250

66123

123

24

D2519



Clamp

Manufactured No

160

Each

79.0000

8

12

11/3/22

Location

Loc Qty

Loc Code

ST456

29

62078

29

ST462

50

65118

50

12

D2529



Washer

Manufactured No

160

Each

982.0000

8

24

11/3/22

Location

Loc Qty

Loc Code

ST016

982

64127

482

66953

500

24

D3049-1



Bearpaw

Manufactured No

160

Each

0.0000

2

6

67169 6/4/3/22

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, March 09, 2011 12:52:55 PM

Work Order ID: 67168

Parent Item: D135-692-011

Parent Item Name: Bearpaw

Start Date: 3/9/2011

Required Date: 3/16/2011

Start Qty: 3.00

Required Qty: 3.00

MS21042L4

Purchased

No

160

Each

4,376.000

8

24



Nut

## Location

## Loc Qty

## Loc Code

ST300

4376

1123143

2

115589

10

115621

20

116188

2344

116823

2000

QS100-M24S

Purchased

No

160

Each

25.0000

4

12



Clamp

## Location

## Loc Qty

## Loc Code

ST449

25

116169

2

116391

3

116513

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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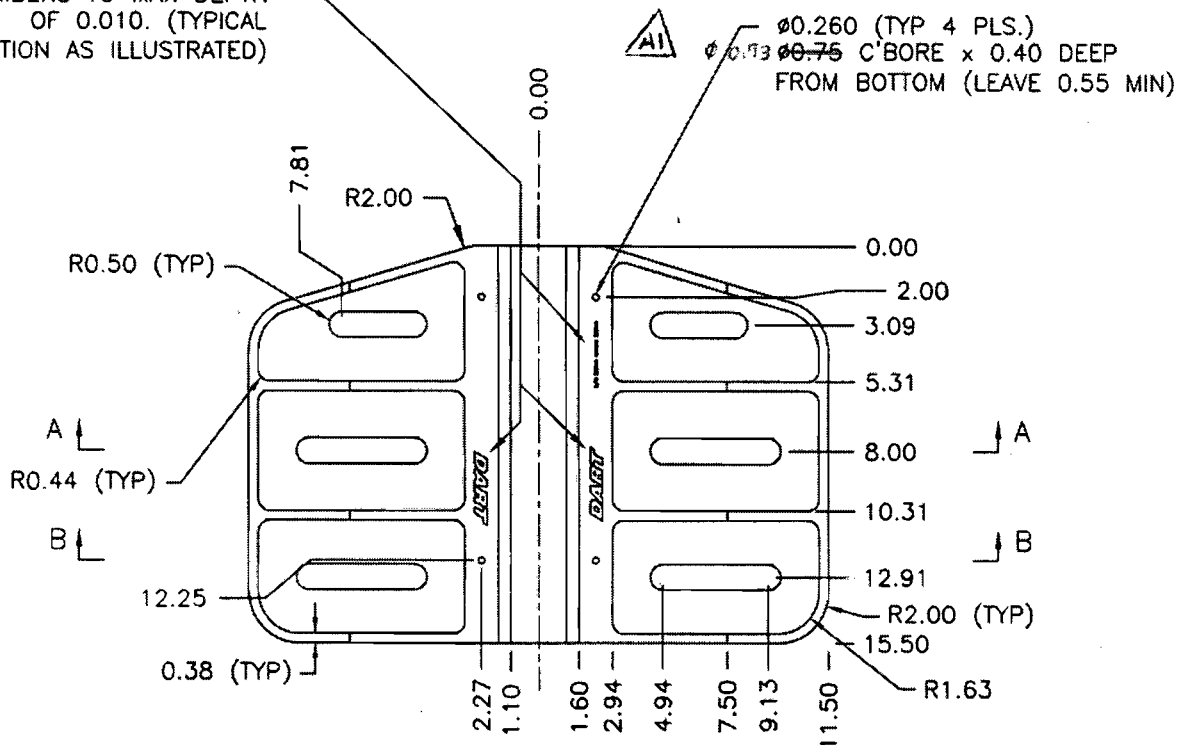
**NOTE:** Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3049	REV. A SHEET 1 OF 2
DATE 01.10.18	TITLE BEARPAW		SCALE 1:7
A	01.10.18	NEW ISSUE	
A1	# RF 03.01.13	Ø 0.73 WAS Ø 0.75	

RELEASED  
01.10.24

ENGRAVE DART LOGO TO  
MAX DEPTH OF 0.012.  
ENGRAVE PART AND BATCH  
NUMBERS TO MAX DEPTH  
OF 0.010. (TYPICAL  
LOCATION AS ILLUSTRATED)



D3049-1 BEARPAW

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 67166

PL 11-03-9

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

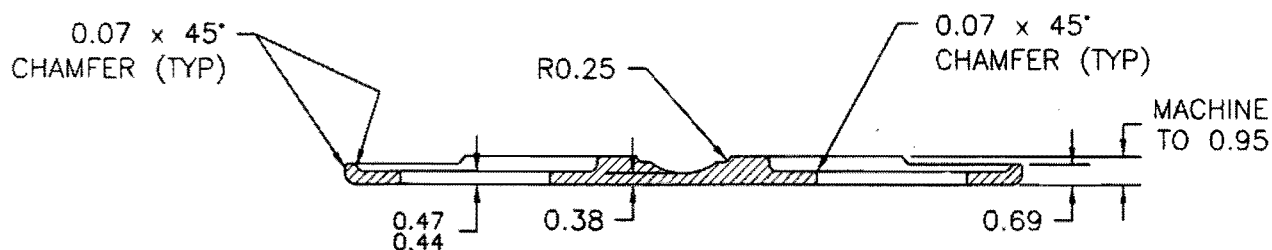
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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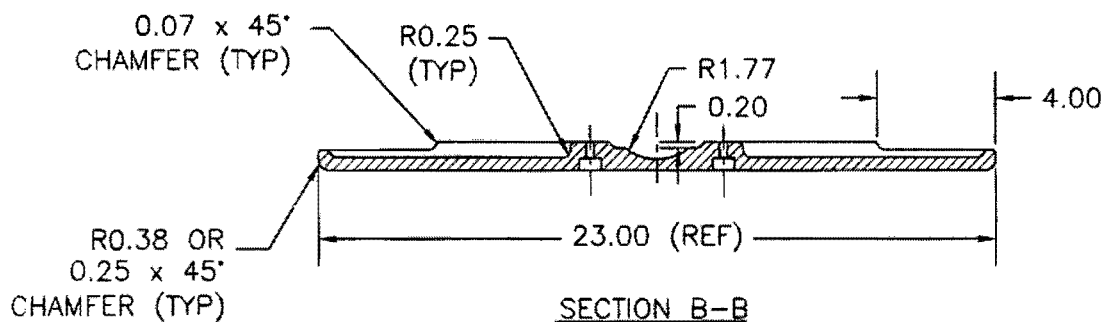
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3049	REV. A SHEET 2 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:6

RELEASED  
01.10.24 H



SECTION A-A

w/0 67168



SECTION B-B

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 32.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D135-692-011 Bearpaw Installation on model EC135 aircraft	11.8 lb 5.36 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	199.7 in 5.07 m	2356 in-lb 27.2 m-kg

## 32.4 PARTS LIST

Qty	Part Number	Description
X	D135-692-011	BEARPAW INSTALLATION
14	D2182B060	RUBBER CUSHION
18	D2274	RADIUS BLOCK
12	D3049-1	BEARPAW
8	D2529	WASHER
4	D2519	CLAMP
8	AN4-15A	BOLT
8	AN960JD416	WASHERS
8	MS21042L4	NUT (OR MS21042-4)
4	QS100M24S	CLAMP